

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022194**Date Inspected:** 26-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Zhen Hua

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 14

Segments 13E and 14E

This QA Inspector observed ZPMC welder Mr. Wu Qingqing, stencil 040779 used shielded metal arc welding process to make tack welds between OBG segment 14E plate SA3338A and various other plates near panel point PP 128. This QA Inspector observed a welding current of approximately 150 amperes (amps), the base materials had been preheated with a torch and Mr. Wu Qingqing appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Yang Junping, stencil 501946 used shielded metal arc welding process to make tack welds between OBG segment 14E plate SA3338B and various other plates near panel point

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PP 128. This QA Inspector observed a welding current of approximately 165 amps, the base materials had been preheated with a torch and Mr. Yang Junping appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 used shielded metal arc welding procedure specification WPS-B-P-2214-T-U4B-FCM-1 to make OBG segment 14E weld SEG3019U-001. This QA Inspector observed a welding current of approximately 160 amps, the base material had been preheated with electric heaters and Mr. Wang Changfa appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-089. This QA Inspector observed a welding current of approximately 175 amps the base materials were preheated with electrical heaters and Mr. Wang Zhengbin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-133. This QA Inspector observed a welding current of approximately 190 amps the base materials were preheated with electrical heaters and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Guanglin, stencil 044779 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-155. This QA Inspector observed a welding current of approximately 180 amps the base materials were preheated with electrical heaters and Mr. Zhao Guanglin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Kuai Wenshan, stencil 054013 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-177. This QA Inspector observed a welding current of approximately 195 amps the base materials were preheated with electrical heaters and Mr. Kuai Wenshan appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

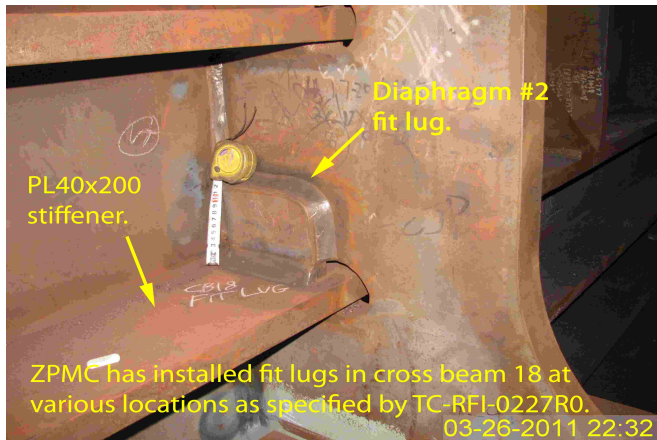
Cross Beam 18, Trial Assembly

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document #TC-RFI-0227R0 and the following field observations were made:

There are four diaphragms that intersect with PL40x200 stiffeners that extend the full length of the cross beam and fit lugs are installed at various locations on each of these four diaphragms as specified by the RFI. A total of seven (7) fit lugs are installed on cross beam 18. Diaphragms #1, #2 and #4 have two (2) fit lugs and diaphragm #3 has one (1) fit lug. Additional information concerning these fit lugs has been submitted to engineering for tracking and evaluations. See the photograph below for additional information.

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Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer